

Date: Tuesday, 16/12/2008 2:13:54 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SHORT STEP ASSEMBLY HIGH SKID LH
<b>Job Number</b>	: 44129		
<b>Estimate Number</b>	: 10575		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D350591213
<b>This Issue</b>	: 16/12/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3078 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 43690	<b>Drawing Revision</b>	: A
	<b>Type</b>	<b>Material</b>	:
	: LARGE FAB ASSY	<b>Due Date</b>	: 09/01/2009
<b>Written By</b>	:	<b>Qty:</b>	4
<b>Checked &amp; Approved By</b>	: <u>JUD 08-12-16</u>	<b>Um:</b>	Each
<b>Comment</b>	: Est Rev:B 05.10.14 Modified step 10 KJ/EC Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM Est Rev:C 06-06-27 Revised as per DSI9340 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL



*for JUD 09/02/13*



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-213 CHG002

2.0

D2622120C

Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2622-120C

Extrusion *B4400402 B42155(27)**SAD 09-02-02*

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

*SAD 09-02-02*

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Sor/02/02 (x4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 44129

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D30671 End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate *34444*

*Sh 09.02.09 4*

6.0 D30631 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3063-1 Support *344162*

*Sh 09.02.09 4*

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072

A/R Aluminum Rod *M108037*

3-Grind End Plate flush

*Sh 09.02.09 4*  
*Sh 09.02.09 4*  
*Sh 09.02.09 4*

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Sh 09.02.10 4*

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Sh 09/02/10 44 LH*

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Sh 09.02.10 4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 44129

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 09-02-10 (4)

12.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B43858

SAD 09-02-10 4

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

B43759 (7)  
B44329 (1)

SAD 09-02-10 4

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

~~2000~~ M110 468

SAD 09-02-10 4

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

SAD 09-02-10 (4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/02/10 (4) (14)

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch  
End Plate B41447

1 D3067-1

End Plate

SAD 09-02-10 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 44129

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod *M103037*

4-Grind End Plate flush

*1/2 09.02.12 4*  
*1/2 09.02.12 4*  
*1/2 09.02.12 4*  
*SAD 09.02.12 (4)*

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 09.02.13 (4)*

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*09.02.13 (4)*

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

*FL 09/02/17*

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: *10:20am*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *10:50am*

*910 09.02.18 (X4)*

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

*FL 09/02/18 (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 44129

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

*09-02-2009/4*

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

26.0

D22301

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp

*44700*

*SS 09/02/19 (X4)*

27.0

D22303

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp

*44701*

*SS 09/02/19 (X4)*

28.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0500 f(s)/Unit Total : 4.2000 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2732-030(3" LONG)

Rubber Cushion

*38509*

*SS 09/02/19 (X4)*

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 2.4000 f(s)

Pick: Packing Kit

Qty Part Number

Description

1 D2856-400(7.2")

Abrasion Strip

*42437*

*SS 09/02/19 (X4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 44129

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

30.0 AN335A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt

M108827

31.0 AN411A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A Bolt

M106605

32.0 AN413A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch:

M110865

33.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer

M110139

34.0 AN960JD416 Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer

M110523

35.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M109798

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID LH

Job Number: 44129

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M69282

SS - 09/02/19 @

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

0902-19 @

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location: 36

PPP Rev: D

96280

SD

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



MR  
09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3078</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, HI SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

**RELEASED**  
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER  
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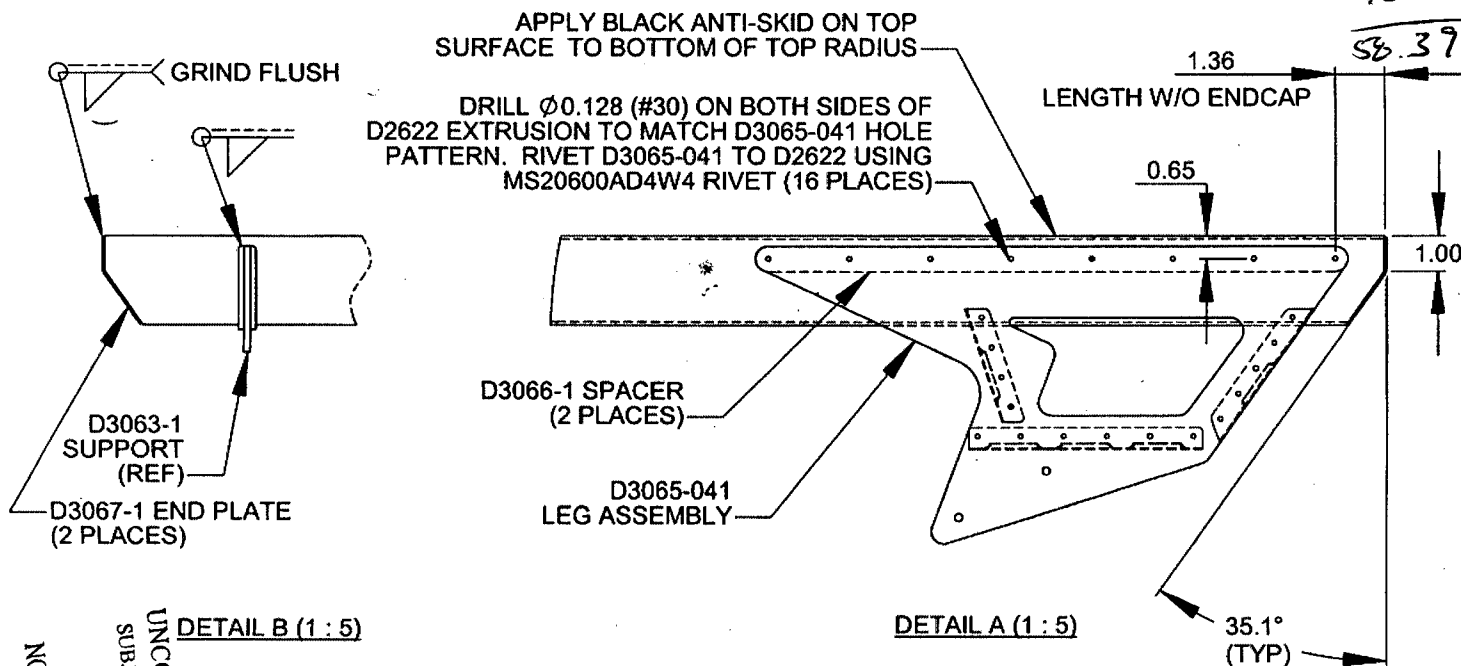
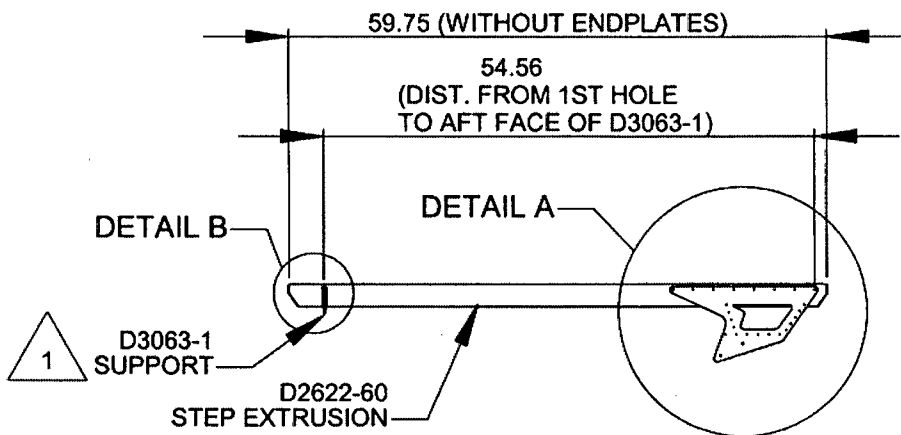
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**DART**



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CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3078	SHEET 2 OF 2
02.09.11		TITLE	SCALE
		STEP ASSEMBLY, HI SHORT	1:20

RELEASED  
02.09.2004



DETAIL B (1:5)

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